

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005669**Date Inspected:** 24-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Dan Hernandez was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 14 OBG Assembly

Segment 6CE

Flux Cored Arc Welding (FCAW) on root pass of weld joint SEG032A-031 located on SP363A to BP115A.

Welder is identified as 038048. ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 6CE

Submerged Arc Welding (SAW) of weld joint SEG032A-031 located on SP363A to BP115A. Welder is identified as 048296. ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 6AE

Shielded Metal Arc Welding (SMAW) of weld joint SEG028A-031 located on SP361A to BP113A. Welders are identified as 067609 and 200114. ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

WELDING INSPECTION REPORT

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Bay 13 OBG Assembly

Segment 1BE

FCAW of weld joint SSD47A-PP11-126 located on FB59A to FB80B. Welder is identified as 055491. ZPMC QC is identified as Huang Shuai. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW of weld joint CSD10A-PP10.5-027, 028, 023, 024, 031, 032 located on CA97A. Welder is identified as 058087. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW of weld joint CSD10A-PP11-089, 090, 085, 086, 093, 094 located on CA97A. Welder is identified as 200113. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW of weld joint CSD10A-PP11.5-091, 092, 087, 088, 095, 096 located on CA98A. Welder is identified as 066028. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Dan	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
